Work Orde July-18-12 2:24		7416		*874	116*						Page 1
Revision ID:	D407-802-0 Baggage Doo	or Opener Installation, Co	omposite	Accept	*N900	<b>040</b>	100	)* s	Setup Sta	IVI	S1* S2*
Start Date: Required Date: Reference:	7/10/12 8/10/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Approvals:		an: MJ	Date: \\(\sigma\)	1 '		ate:		I	Run Sta Sto	<i>"\</i>	R1* R2*
Sequence ID/ Work Center II	,	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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IIN-D407-802- IIN-D407-802-											
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*100 *100* DC Document Control		DOCUMENT CONTRO Memo Photocopy b	DL pluefile and create labels	0.00 0.00 \$.5 per PPP D407-802-019	CHGOOL JB			\$	r601)	MUJ	12-10-1
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												DQA:	Date:	* */
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFORM	<b>JANCE / UPI</b>	DATE			
												QA Closed:	Date:	
Nork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Part i	•						Rework Scrap Use-as-is		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing			4	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR I	No.						Work Order Update		1	Large Fab	Composite	]	Supplier	
Root					Desc	rip	otion of work order update	ı	nitial	Act	ion	Sign &		
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		Bending				$\dashv$	Bend		Grain			Ovalized		Pressure/Forced
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		Cracks			L		Broken/Damaged		Inspecti	on Incomplete	L	Part Incorred	t	Weld
	Crushed/Crimped.			Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
		Cuffs					Contamination		Mainte	nance	1	Part Moved		_
Heat Treat				Countersink		Mislabe	led		Positioned Wrong					
	Inspection Strip in Tube				Cut Too Short		Misread	f		Power Loss/:	Surge	Other		
,		Ripples in	Bend				Drill Holes		Offset			<del>-</del>		
		Torque W	aves in E	xtrusio	n [		Drawing		Out of 0	Calibration				
		Turning Se	equence		Γ		Finish		Out of S	equence				
		Wave/Twi	ist in Tub	e	Γ		Folio	Г	Outside	Dimensions				

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Work Order ID:

87416

Parent Item:

D407-802-019

Parent Item Name:

Baggage Door Opener Installation, Composite

**Start Date:** 7/10/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 10.09.27 new issue DD verf:EC

IPP Rev:B 10.12.03 as per dwg

	rev.A DD verf:EC	2											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measu		Qty per Kit	Total -Qty	Qty Issued	Date Issued	Status
D3552-10 Door Prop		Manufactured	No			105	Each	10.0000	88	102 _	JB		
•				<b>Location</b>		Loc Qty		Loc Code				•	
				ST272		10							
				696	69	10				<del>}</del>	<u>_</u>		<b>A</b>
D41094041 Doubler Assembly, Bulkh	ead	Manufactured	No			105	Each	2.0000		1	JB	-fur-	
				Location		Loc Oty		Loc Code			·		•
/				ST097		2							
A				764	35	. 2			14	435			_
D4109-043 Doubler Assembly		Manufactured	No			105	Each	6.0000		1	~ J.E	<b>&gt;</b>	8
·				Location		Loc Qty		Loc Code			,		•
				ST097		6				share a			
				764	63	6			16	403			
80=004=2 <u>=</u> 6		Purchased	No			105	Each	204.0000	3	3			
1110414				<b>Location</b>		Loc Qty		Loc Code			0		
				ST379		204			*****				
				120	)273	50							
)					055	54			121	055			_/
				121	500	100				7—			ع ا
MS27039C1-05 SCREW		Purchased	No			105	Each	155.0000	<u> </u>	4	13B	127	10/12
				Location		Loc Qty		Loc Code			V	,	•
				ST293		155							
					6574	12				<del></del>			
				103	7242	143			10	1242	,		

NCR:	/es	/ No					WORK ORDER NON-C	O	<b>NFORM</b>	AANCE / UPD	ATE		<u> </u>	
						-						QA Closed:	Date:	
Work Orde	er: _						DISPOSITION	1			_	EPARTMENT,	<del></del>	
Part No.						Rework Scrap Use-as-is		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing		<b>⊣</b>	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR I	۱o. <sub>.</sub>						Work Order Update	]		Large Fab	Composite _	_]	Supplier	
Root					Desc	rip	tion of work order update		nitial	Acti	on	Sign &		
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
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		Bending					Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to (	o/s [		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld		
	Crushed/Crimped.				Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/M	issing	Wrong Stock Pulled		
	Cuffs				Contamination		Mainte	nance	Γ	Part Moved		_		
		Heat Trea	t				Countersink		Mislabe	eled		Positioned \	Vrong	_
		Inspection	n Strip in	Tube			Cut Too Short		Misread	d		Power Loss/	'Surge	Other
		Ripples in	Bend		ſ		Drill Holes		Offset		_			
		Torque W	aves in E	xtrusio	n [		Drawing		Out of 0	Calibration				
		Turning S	equence		[		Finish		Out of	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

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## Picklist Print

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Page 2

July-10-12 2.24.5										
Work Order ID: Parent Item: Parent Item Name:	87416 D407-802-019 Baggage Door Opener Installation, C	omnosite					Date: 7/10/12 Qty: 1.00		Required Date: Required Qty:	
				105	E - d			•		
MS27039 C1106	Purchased	No		105	Each	23.0000	3	3	21	
2010#			<u>Location</u>	Loc Qty		Loc Code				26
			ST293	23						
			115768	23			11576	68		* * ·
NASI149G0363R Washer	Purchased	No		105	Each	5,005.0000	7	7	~ 1B	Swell
<b>.</b>			Location	Loc Qty		Loc Code				
			297	2000						
			122441	2000						
			ST297	3005				<del>-</del> /		
			114742	2805			11474	8		O A
			122063	200						
NAS1836-3-08M Insert	Purchased	No		105	Each	22.0000	40	4	JB	12/10/
			Location	Loc Oty		Loc Code			V	. /
			ST278	22			0 <del></del>			,
			115768	2			241127	68		
			120422	20			241204	20		

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	100	VFORM	AANCE / UPDAT		OA Classel	Data	•
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Vork Ord	er:						DISPOSITION			A	GAINST DE	PARTMENT/	PROCESS	
	Part No.						Rework Scrap		Skid-tube Crosstube  Machining Small Fab				Water Jet	Engineering Quality
NCR	No.						Use-as-is Work Order Update			· · · · · · · · · · · · · · · · · · ·	inishing mposite	Rec/Stor	e/Packaging Supplier	Other
Root					Des	crip	otion of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty			r Non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Inspector
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Land	ing (	Gear			i		General		,		٠	•		_
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
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Outside Dimensions

Wave/Twist in Tube

Folio

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# Change Record

Part Number:

D407-802-019

PAGE 1 OF

Description:

BAGGAGE DOOR OPENER, COMPOSITE

CHG#	DATE	BY	RELEVANT DOCUMENTS	ECN#
001	10.12.01	KJ	MDL-D407-802 REV. A	10-655
002	12.07.24	KJ	D3552 REV. K	12-624
				<u> </u>
				<u> </u>

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# REFERENCE ONLY

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### 5.3 D407-802-017/-018 Passenger Door Opener Kits

Qty -017	Qty -018	Part Number	Description
$\stackrel{"}{>}$	-0.0	D407-802-017	PASSENGER DOOR OPENER KIT, LH
	> <	D407-802-018	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	1	D3622-5	BALL STUD
1		D4108-1	DOOR DOUBLER, LEFT
	1	D4108-3	DOOR DOUBLER, RIGHT
	1	D4108-5	SMALL RIGHT DOOR DOUBLER
	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
1		D4108-049	LITTER DOOR FITTING ASSEMBLY
	19	CR3523-4-2	RIVET
21		CR3523-4-3	RIVET
	4	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
	2	MS20426AD4-6	RIVET
1	1	MS21073L5	ANCHOR NUT
3		MS21209-F1-15	HELICOIL
3		MS27039C1-06	SCREW
1		MS27039C1-09	SCREW
2	2	MS27039C1-27	SCREW
2	2	NAS1149C0332R	WASHER
2	2	NAS1149C1165R	WASHER
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

#### D407-802-019 Baggage Door Opener Kit, Composite 5.4

	Qty -019	Part Number	Description
	> <	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
Į			
4	1	D3552-19	-DOOR PROP
ſ	1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
I	1	D4109-043	DOUBLER ASSEMBLY
I	<b>/</b> 3	.80-004-2-6	INSERT
ľ	4	MS27039C1-05	SCREW
ſ	/3	MS27039C1-06	SCREW/
1	7	NAS1149C0363R	WASHER
1	7 4	_NAS1836-3-08M	-INSERT

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Revision: A

Date: 10.10.13